

June

Dart Aerospace Ltd.

Date: Thursday, 23/04/2009 1:40:11 PM
 User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|---|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SADDLE ASSEMBLY |
| Job Number | : 47406B | | |
| Estimate Number | : 11180 | | |
| P.O. Number | : | Part Number | : D2282043 |
| This Issue | : 23/04/2009 S.O. No. : | Drawing Number | : D2282 REV E |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : SMALL /MED FAB | Drawing Revision | : E |
| Previous Run | : 46685 | Material | : |
| Written By | : | Due Date | : 30/04/2009 Qty: 60 Um: Each |
| Checked & Approved By | : <u>JD 09.04.23</u> | | |
| Comment | : Est Rev:A Removed from 9 Digit 05-12-02 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------|-------------|
| 1.0 | D2281 | Jack Saddle |
|-----|-------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

| | | |
|-----------------|-------------|-----------------------------------|
| Qty Part Number | Description | Batch |
| 1 D2281 | Saddle | B 4538-3 = 25 X B 46831 = 35 X |

SP 09.05.11

| | | |
|-----|--------|------|
| 2.0 | D22827 | Tube |
|-----|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick:

| | | |
|-----------------|-------------|------------------------------|
| Qty Part Number | Description | Batch |
| 2 D2282-7 | tube | B 46890 = 119 B 45386 = 1 |

SP 09.05.12

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

| | | | |
|-----|-----------|-------------|-------------------|
| A/R | ER316L SS | Filling Rod | M 102421 M 108775 |
| | | Dwg Rev: | E |

SP 09.05.13

Look

| | | |
|-----|-------------|-------------------------------|
| 4.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush, take all welding marks out and deburr holes

M. 04/05/06 Look
 SP 09.05.14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 1:40:11 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 47406B

Part Number: D2282043

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 09-05-27

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/05/27

(60)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-tumble

NIA

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GR*

SB 09/05/27

(60)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/27

Job Completion



ME 09-05-27

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|-------------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 09.05.27 | 7 i g | Steps no longer necessary. To reduce lead time parts will be polished with a blue pad, and no longer tumbled. Perm change. | EC | 09.05.27 | | 09.05.27 | 150527 |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

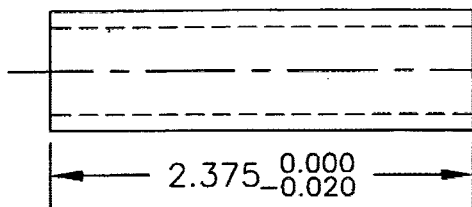
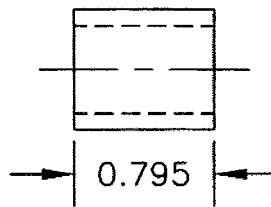
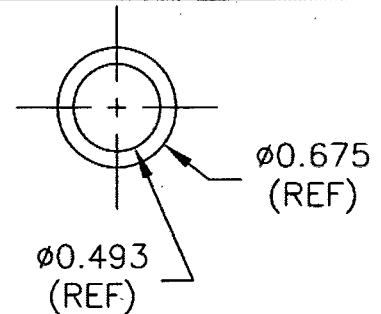
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

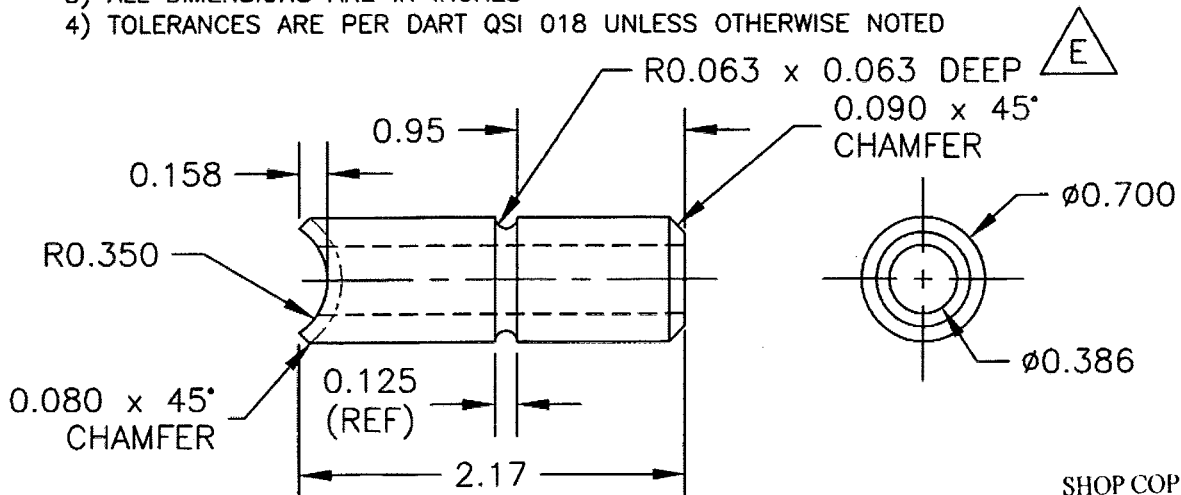
DART**RELEASED**

05/09/16

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2282 | REV. E SHEET 1 OF 2 |
| DATE 05.06.07 | | TITLE HANDLE TUBES | SCALE 1:1 |
| A | 94.10.14 | NEW ISSUE | |
| B | 95.03.23 | RE-DESIGN | |
| C | 97.10.20 | CORRECTED NUMBERING SCHEME | |
| D | 05.03.16 | REDESIGN D2282-5; 0.795 WAS 0.750 | |
| E | 05.06.07 | D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030 | |

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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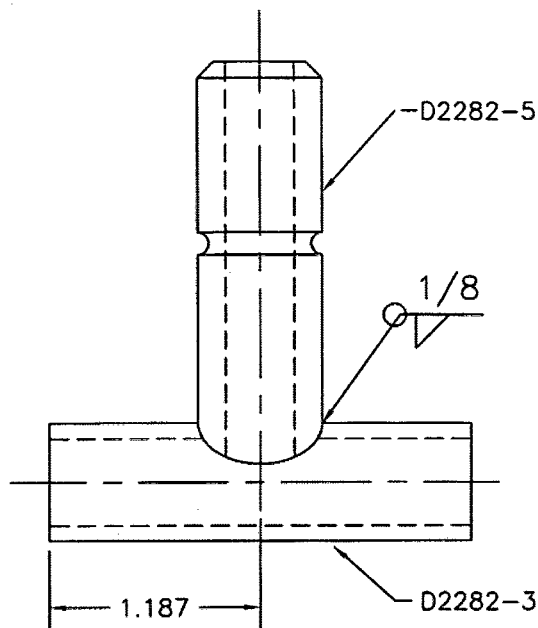
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WORK ORDER
NO. *474068*

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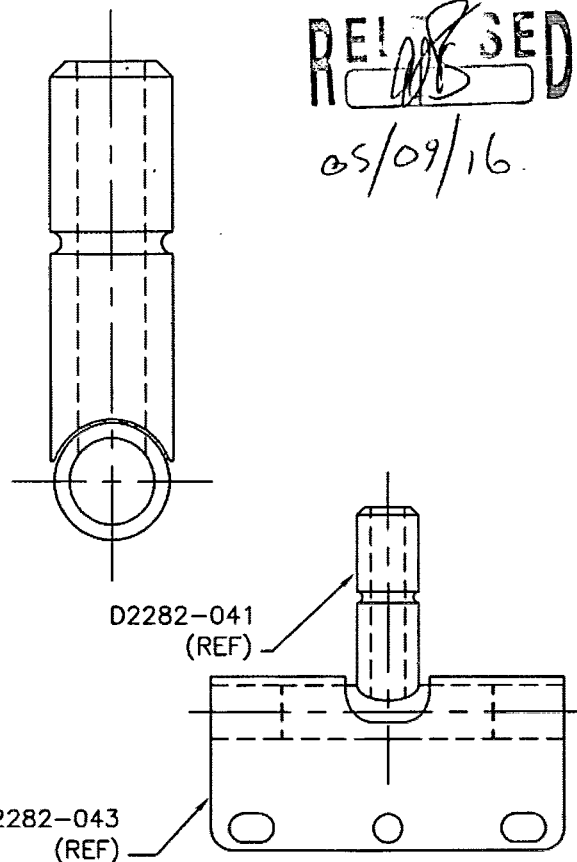
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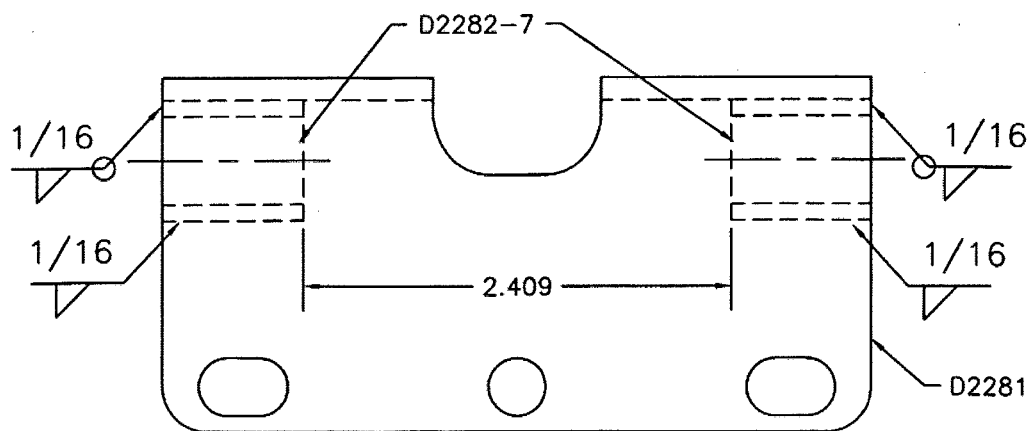
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|----------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>UP</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2282 | REV. E SHEET 2 OF 2 |
| DATE 05.06.07 | | TITLE HANDLE TUBES | SCALE 1:1 |



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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